

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017758**Date Inspected:** 01-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** N / A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI reviewed contract related documents including the submitted and approved Welding Quality Control Plan (WQCP) and approved revisions to the WQCP. The QAI continued consolidating the information from previous welding report submittals to identify missing reports of inspections. The QAI continued generating a weld specific tracking list from the contractor's welding reports.

The QAI observed ABF personnel tack welding shim plates onto orthotropic box girder (OBG) segments 9E and 9W. The QAI noted that the shims are located at the cross beam transition openings for the support cradle bearings. The QAI observed welder Richard Bazewicz, ID 3068, is using shielded metal arc welding (SMAW) with E7018 H4R electrodes to make the temporary filled welds. The QAI noted that the Quality Control (QC) Inspector William Norris is monitoring the fillet welding. See the attached photos. The QAI noted that these shims have previously been installed on other OBG segments prior to erection. The QAI asked the QC Inspector if there is an approved drawing for these temporary welds, as there has not been in the past. The QAI noted that this welding has been documented with non-conformance reports from ABF and non-conforming incident reports. The QC Inspector responded that he was only aware of the temporary weld requirements from submittal 1361 rev. 2. The QAI informed the QC Inspector that there is a newer revision to submittal 1361 and it does not include weld details for these shim plates.

The QAI relayed the observations of shim plate welding and the apparent lack of approved drawings for the shim

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plate details to the QAI Lead Bill Levell. The QAI reviewed previously issued non-conformance incident reports and submittals to identify the work / details for the work being performed. The QAI Lead was informed of the location of welding and type of welding. The QAI was informed that this matter will be discussed with the contractor during the meeting scheduled for tomorrow, 11-02-2010.

Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI had conversations with the QC Inspector William Norris and the QAI Lead Bill Levell regarding the shim plate welding, as described above. The QAI relayed the status of submittal and document reviews to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations or observations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi, (916) 813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
